

Date: Tuesday, 7/1/2008 2:34:33 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT BASE		
Job Number	: 40193			Part Number	: D36513		
Estimate Number	: 13031			Drawing Number	: D3651 REV.B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 7/1/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 7/25/2008		
Previous Run	: 37165			Qty:	4	Um:	Each
Written By	:			108.01.01			
Checked & Approved By	:						
Comment	: Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD Est Rev:C ecn1162 08-04-02 DD verified by: EC						

## Additional Product

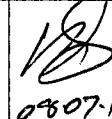
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S26GA	304/316 0.018 SHEET
		 Comment: Qty.: 0.4977 sf(s)/Unit Total : 1.9908 sf(s) 304/316 SS sheet 26 ga (0.018" thick) Batch: 108.415 RB 8-7-4
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D3651 Dwg Rev: B Prog Rev: B HB 8-7-4
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 8-7-4
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 8-7-4
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK S 06/07/04
5.0	BRAKE NC	NC BRAKE
		 Comment: NC BRAKE Form as per Dwg D3651 B 08-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3651-3 PAR #: N/A Fault Category: Prod/Proc. Ass. not Brought NCR: Yes No DQA: D Date: 08/07/09  
QA: N/C Closed: D Date: 08/07/09

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/15	5	Two parts bent out of tolerance *	 08/07/15	Scrap & destroy no replace	 08/07/16	S 08/07/16	 08/07/16	5 08/07/16

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:34:33 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE

Job Number: 40193

Part Number: D36513

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08 (7/16 X 3)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: GA

S 08/07/17 (3)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/18 (3)

Job Completion



Mo 08/07/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

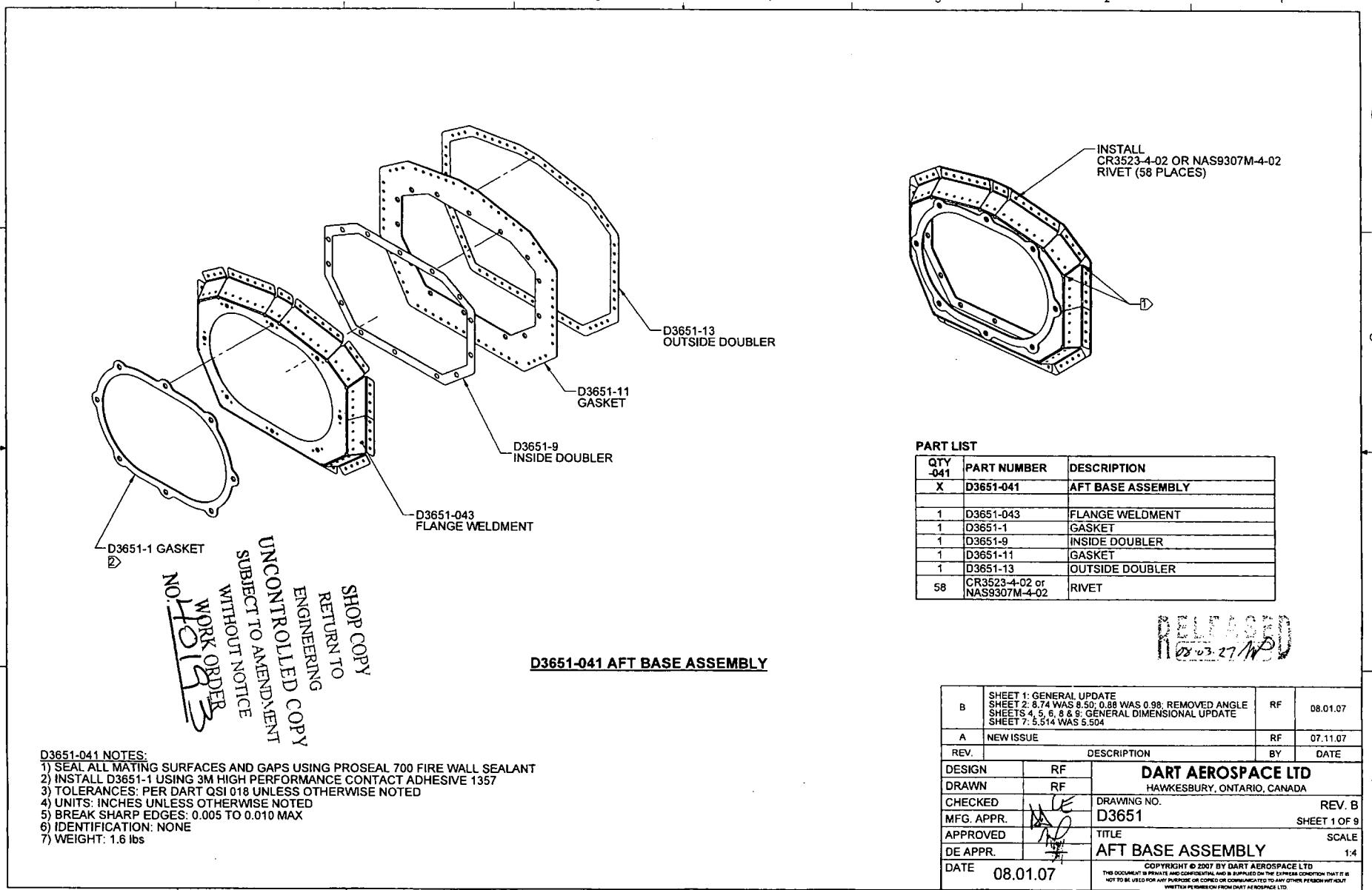
<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>40193</b>
<b>Description:</b> Base	<b>Part Number:</b>	<b>D3651-3</b>
<b>Inspection Dwg:</b> D3651 <b>Rev:</b> B		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

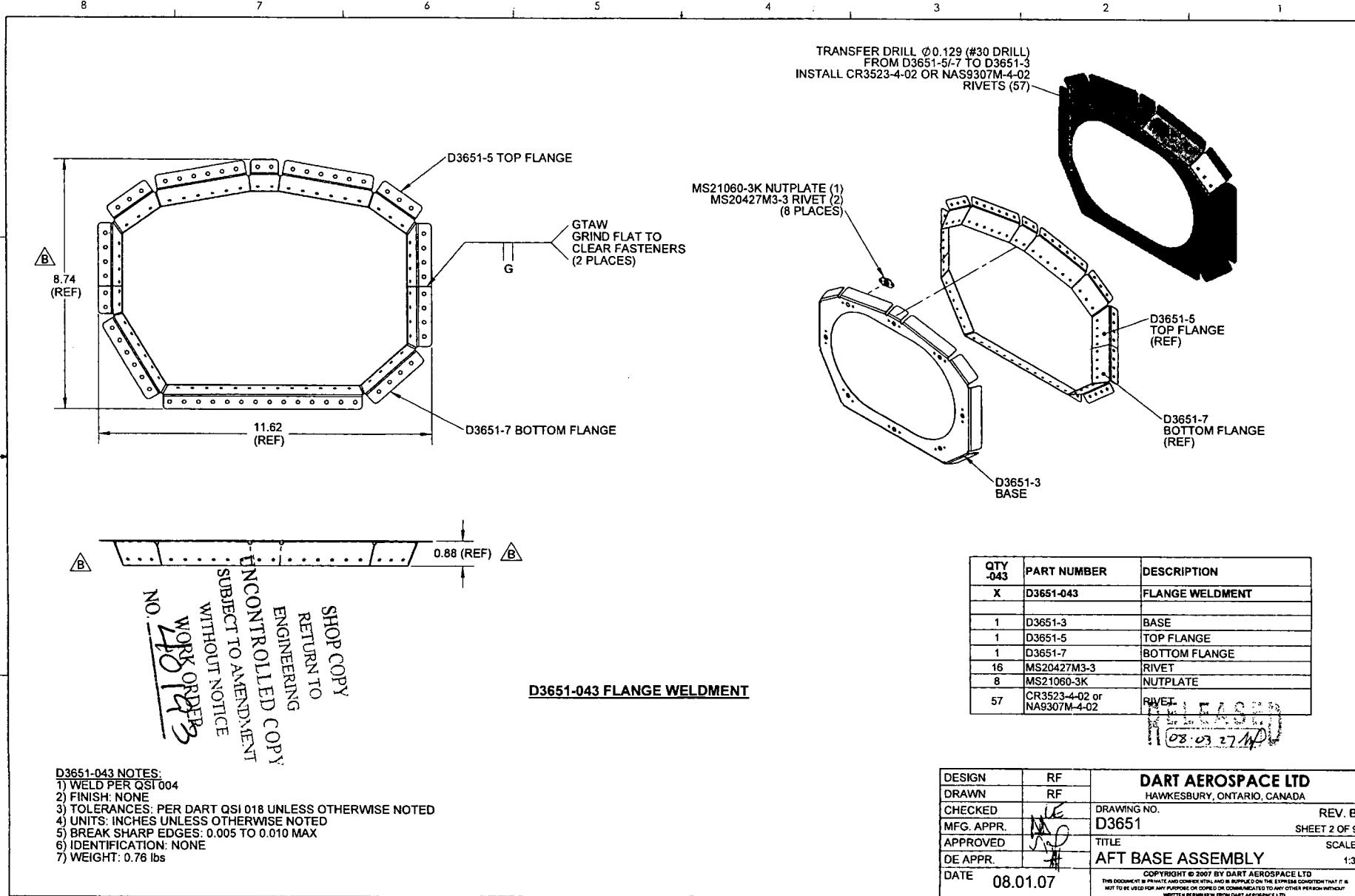
## X First Article Prototype

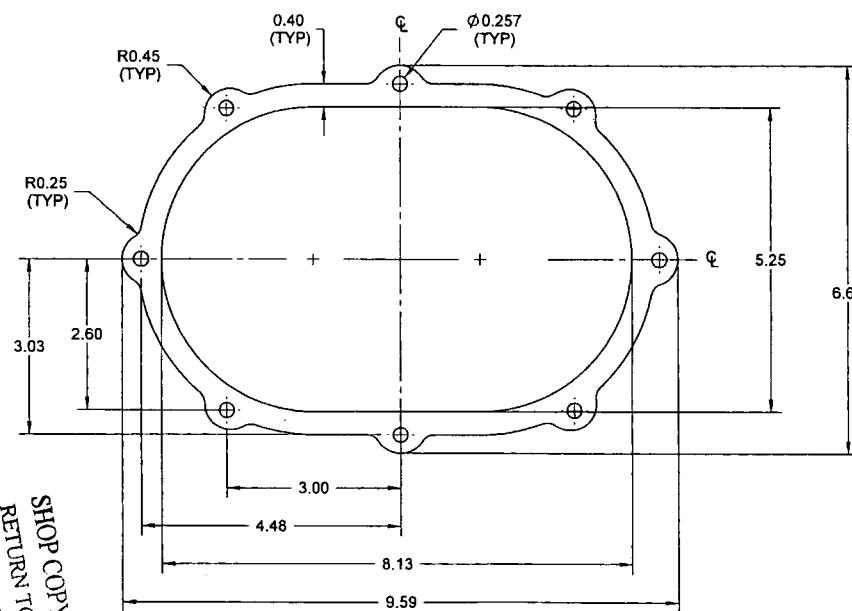
Measured by:	PB	Audited by:	SJ	Prototype Approval:	N/A
Date:	8-7-4	Date:	08/07/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	



B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.53, 0.88 WAS 0.98; REMOVED ANGLE SHEET 5: 4, 5, 6, 7 & 8. GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	DRAWING NO.	REV. B
MFG. APPR.	DA	D3651	SHEET 1 OF 9
APPROVED	RD	TITLE	SCALE
DE APPR.	RD	AFT BASE ASSEMBLY	1:4
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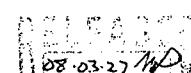
**D3651-1 GASKET**

#### NOTES:

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)  
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT  $\varnothing$
- 8) WEIGHT: 0.09 lbs

NO. 40193  
WORK ORDER  
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RETURN TO  
SHOP COPY



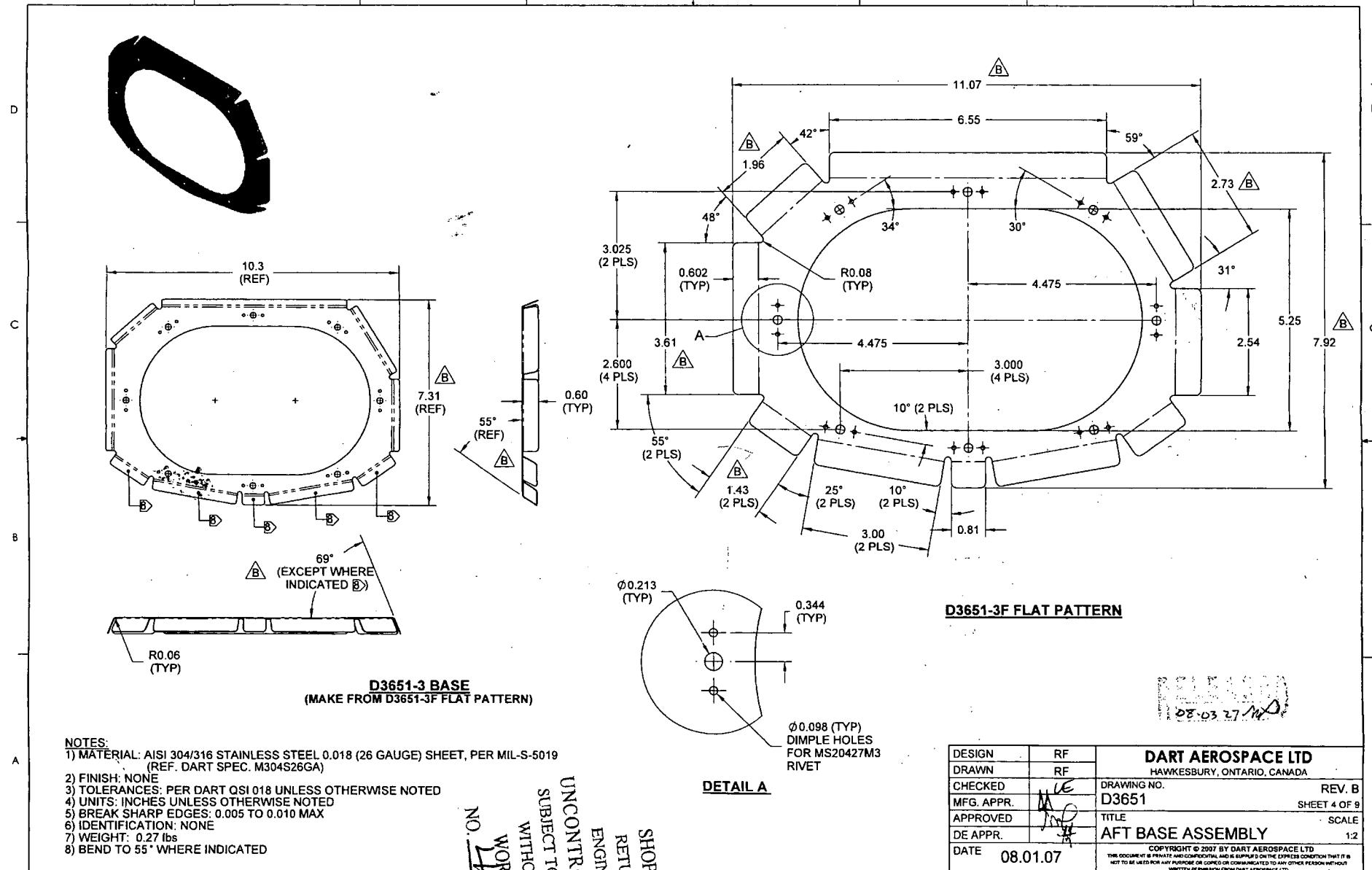
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	<i>LE</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>BL</i>	D3651	SHEET 3 OF 9	
APPROVED	<i>AM</i>	TITLE	SCALE	
DE APPR.	<i>SH</i>	AFT BASE ASSEMBLY		
DATE	08.01.07	1:2		

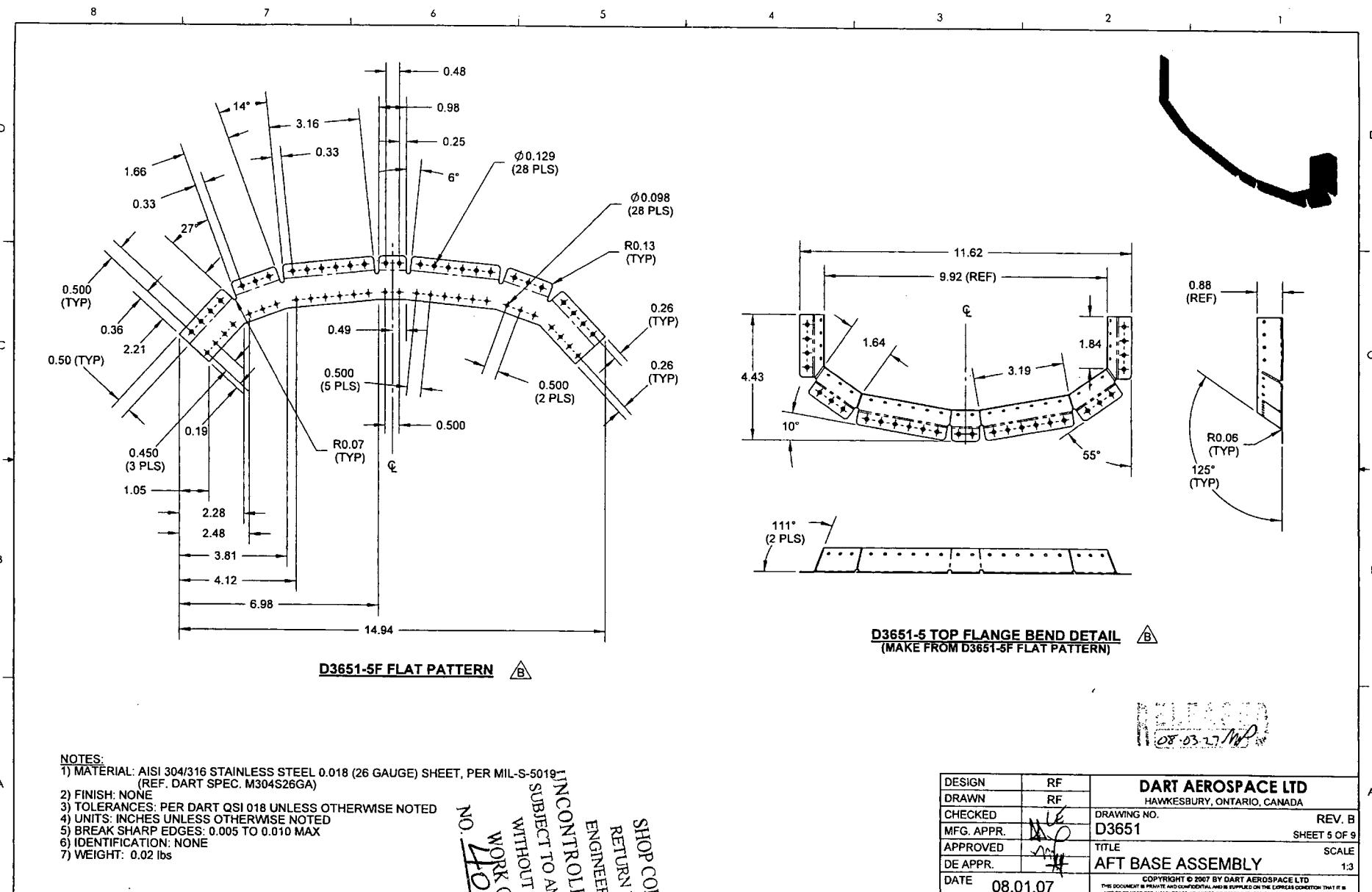
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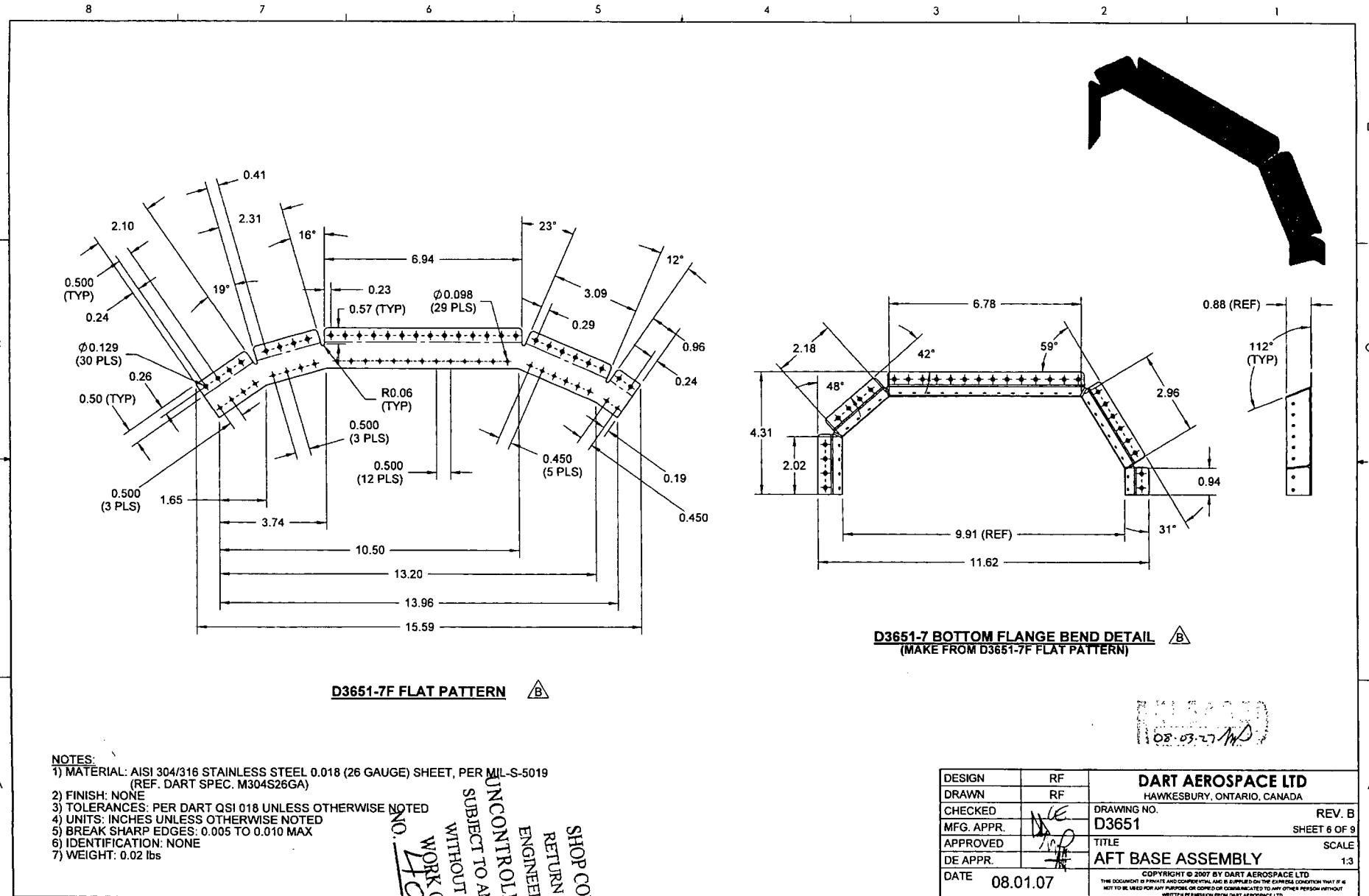
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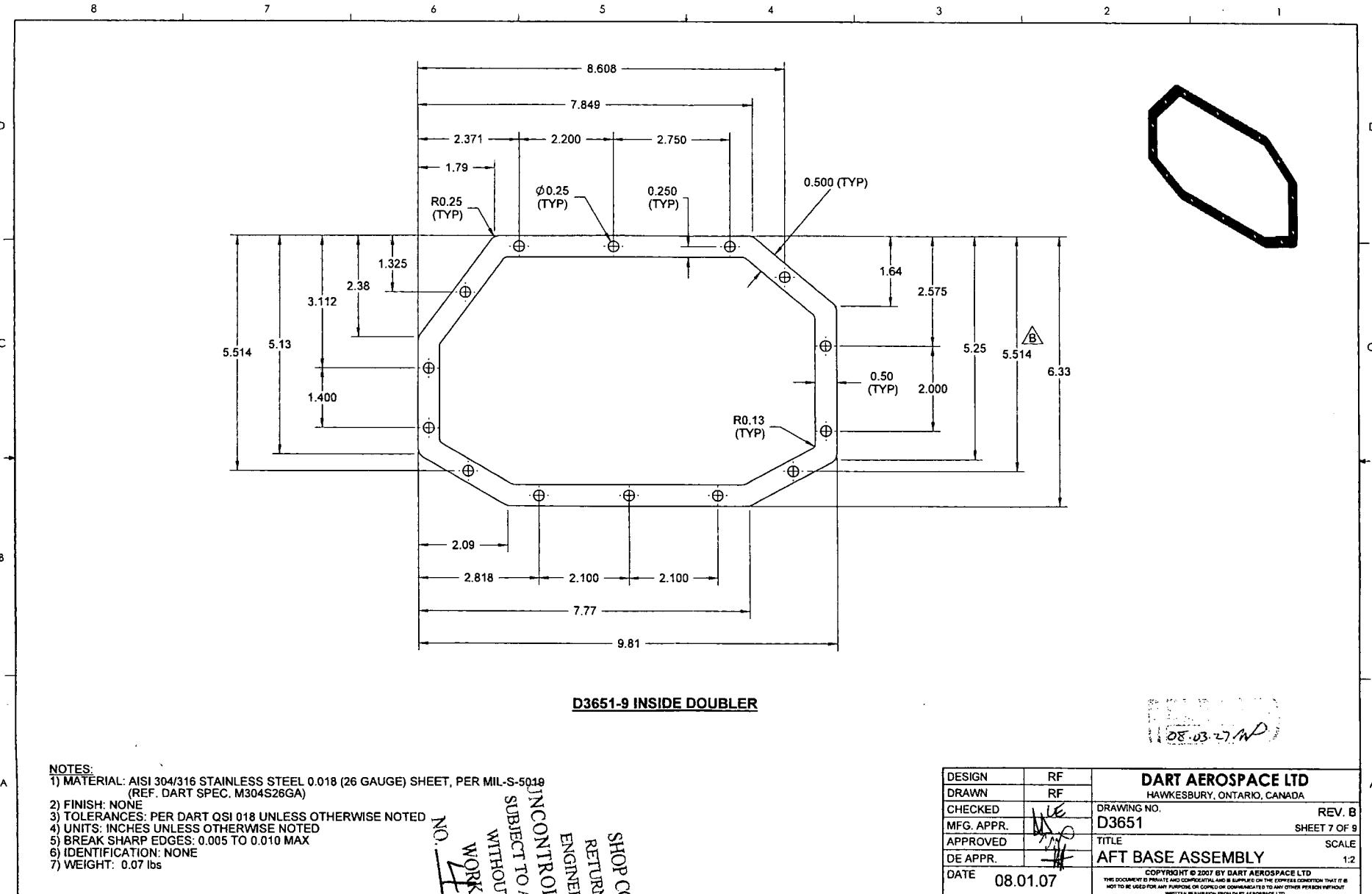
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8 7 6 5 4 3 2 1





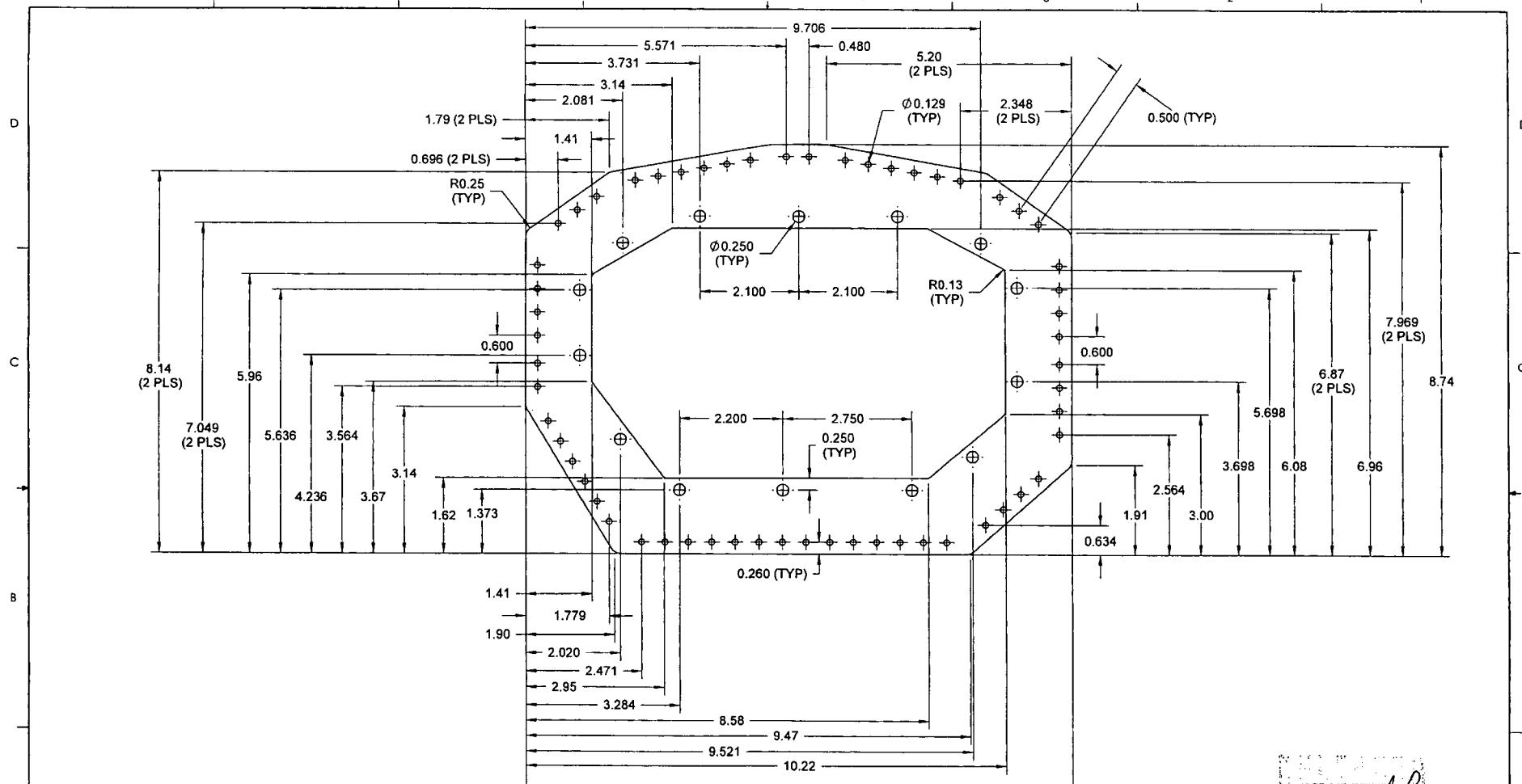




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CHECKED	<i>LE</i>	DRAWING NO.
MFG. APPR.	<i>LE</i>	REV. B
APPROVED	<i>LE</i>	D3651
DE APPR.	<i>LE</i>	SHEET 7 OF 9
DATE 08.01.07		TITLE
		SCALE
		<b>AFT BASE ASSEMBLY</b>

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8 7 6 5 4 3 2 1



## NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)  
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.2 lb

D3651-11 GASKET △

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WITHOUT NOTICE  
WORK ORDER NO. *470-193*

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CHECKED	<i>VE</i>	DRAWING NO.
MFG. APPR.	<i>AN</i>	REV. B
APPROVED	<i>TC</i>	SHEET 8 OF 9
DE APPR.	<i>TC</i>	TITLE
		SCALE
		1:2
		DATE 08.01.07

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28.03.27 *MP*

